

Date: Tuesday, 10/17/2006 11:21:44 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HINGE BRACKET
Job Number : 29051	
Estimate Number : 10345	
P.O. Number : N/A	Part Number : D28571
This Issue : 10/17/2006 S.O. No. : N/A	Drawing Number : D2857 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A1
Previous Run : 26501	Material : N/A
Written By : <u>HA 061017</u>	Due Date : 11/2/2006 Qty: 24 Um: Each
Checked & Approved By : <u>HA 061017</u>	
Comment : Est C 00.06.22 Removed P/O for powder coat EC Est D 06.05.01 Added level 8 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B2000X01250	6061-T6 Bar 2.0" x 1.25"
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Comment: Qty.: 0.4594 f(s)/Unit Total : 11.0250 f(s)

Material: 2.00" X 1.25"

6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)

(M6061T6B200001250)

Batch M16615

En 06/11/13 x 24

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks 5.2"

En 06/11/13 x 24

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio D2857-1

En 06/11/17 x 24

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En 06/11/17 x 24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/17/2006 11:21:44 AM
User: Kim Johnston

Process Sheet

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Drawing Name: HINGE BRACKET

Job Number: 29051

Part Number: D28571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 06/11/19

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

En 06/11/17 x24

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

SAD 06/11/14

(24)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/11/20 (24)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

FR/AM 06/12/29

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MM 07/01/02

24

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 391

PB 07/01/03 (24)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/03

Job Completion



07/01/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	29051
Description: Hinge Bracket		Part Number:	D2857-1
Inspection Dwg: D2857 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.293	/			
0.340	+/-0.010	0.341	/			
1.110	+/-0.005	1.113	/			
1.790	+/-0.010	1.794	/			
1.320	+/-0.005	1.317	/			
2.000	+/-0.010	1.990	/			
Ø0.171	+0.005/-0.000	0.175	/			
0.147	+/-0.010	0.147	/			
0.376	+/-0.010	0.372	/			
0.126	+/-0.010	0.129	/			
0.063	+/-0.010	0.061	/			
Ø0.166	+0.005/-0.000	0.167	/			
0.911	+/-0.010	0.911	/			
0.600	+/-0.010	0.603	/			
0.125	+/-0.010	0.131	/			
0.150	+/-0.010	0.152	/			

Measured by:	En	Audited by:	WJ	Prototype Approval:	N/A
Date:	06/11/15	Date:	06/11/16	Date:	N/A

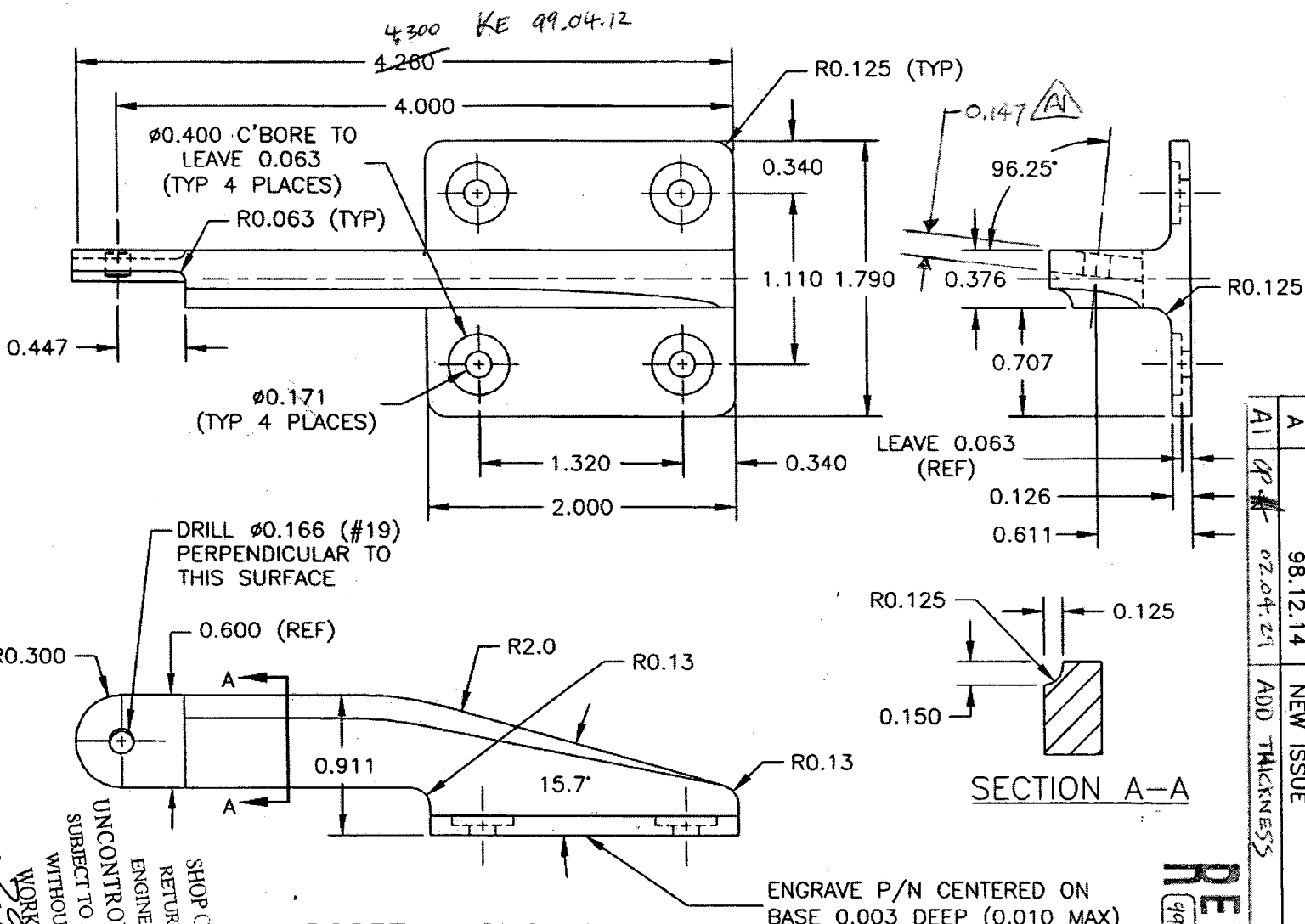
Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	AS

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	SP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	SP	D2857
DATE	TITLE	REV. A
98.12.14	HINGE BRACKET	SHEET 1 OF 1
SCALE		
1:1		
ADD THICKNESS		
A1	98.12.14	NEW ISSUE

RELEASED
99.01.06 KE



D2857-1 SHOWN
D2857-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)
FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 29051